











Date: Thursday, 15/01/2009 11:23:32 AM
User: Julie Dawson

Process Sheet

| | | |
|--|------------------------------|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : STUD | |
| Job Number : 44826 | | |
| Estimate Number : 13141 | | |
| P.O. Number : 1 | Part Number : D36911 | SA 09/01/27 No more material 24 Um: Each |
| This Issue : 15/01/2009 S.O. No. : | Drawing Number : D3691 REV B | |
| Prsht Rev. : NC | Project Number : N/A | |
| First Issue : 11 Type : MACHINED PARTS | Drawing Revision : B | |
| Previous Run : 44688 | Material : | |
| Written By : | Due Date : 30/01/2009 | Qty: |
| Checked & Approved By : JCD 09.01.15 | | |
| Comment : Rev:A New Issue 08-01-29 JLM Verified By:EC Est Rev:B Material Change 09-01-07 JLM Verified By:EC | | |

Additional Product

Job Number: 

| Seq. #: | Machine Or Operation: | Description : |
|---------|---|---|
| 1.0 | M174PHH900R1000 | 17-4PH SS ROUND BAR 1.00 COND.900 |
| |  |  |
| | Comment: Qty.: 0.7350 f(s)/Unit Total : 17.646 22.0600 f(s) 17-4PH SS ROUND BAR 1.00 ****CONDITION H-900**** BATCH: M110590 up 09/01/25 SA 09/01/27 | |
| 2.0 | BAND SAW | BAND SAW |
| |  |  |
| | Comment: BAND SAW Cut blank 7.850" long SA 09/01/27 (24) | |
| 3.0 | DOOSAN LATHE | DOOSAN LATHE |
| |  |  |
| | Comment: DOOSAN LATHE 1-Turn as per Folio FA716 Rev: N/A & Dwg D3691 Rev: B 2-Deburr per dwg D3691 SA 09/01/27 (24) | |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| |  |  |
| | Comment: INSPECT PARTS AS THEY COME OFF MACHINE SA 09/01/27 (24) | |
| 5.0 | LATHE CONV. | CONVENTIONAL LATHE |
| |  |  |
| | Comment: CONVENTIONAL LATHE Face to finished length as per dwg D3691 AND center drill as per Dwg D3691 SA 09/01/27 (24) | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 15/01/2009 11:23:32 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STUD

Job Number: 44826

Part Number: D36911

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 05/01/27

(24)

7.0

DOOSAN LATHE

DOOSAN LATHE



Comment: Doosan Lathe

1- Turn as per Folio FA716 Rev: N/A & Dwg D3691 Rev: B

2-Deburr per dwg D3691

SA 05/01/28

(24)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 05/01/28

(24)

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 09/01/28

(24)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 117

9/1/29

56

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/02

Job Completion



JUD 09.01.29 (24)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|------------------------------|--|--------------|--------|
| PART AEROSPACE LTD | | Work Order: | 74826 |
| Description: 3TUD | | Part Number: | 3691-1 |
| Inspection Dwg: D3691 Rev: B | | Page 1 of 1 | |

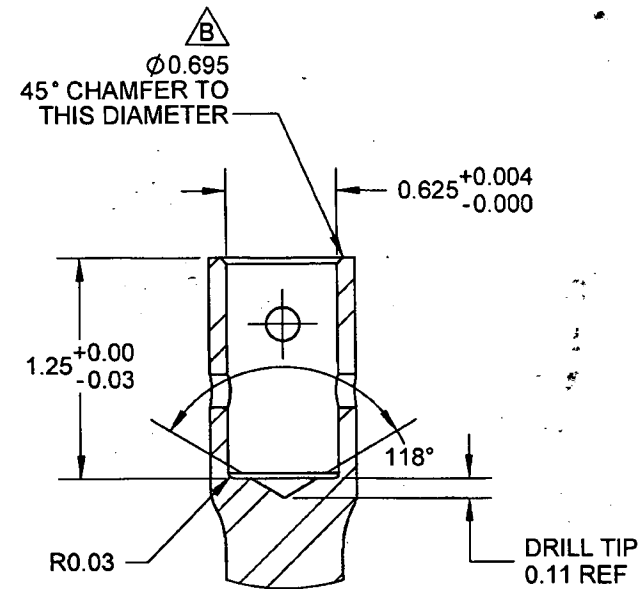
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

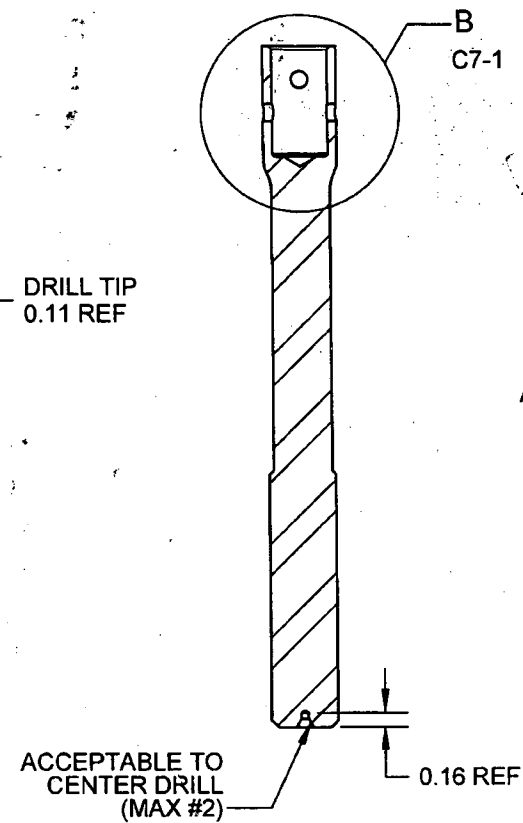
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|--------------------------|------------------|--------|--------|----------------------|----------|
| .625 | +0.004 -0.000 | .625 | / | | | |
| 1.25 | ±0.000 -0.030 | 1.245 | / | | | |
| Ø.825 | +0.006 -0.002 | Ø.826 | / | | | |
| Ø.189 | +0.005 -0.001 | Ø.190 | / | | | |
| .750 | +0.000 -0.010 | .742 | / | | | |
| Ø.659 | +0.009 -0.015 | Ø.651 | / | | | |
| Major Ø | Max. .7485 Min. .7321 | .747 | / | | | |
| M.O.W. | Max. .7737 Min. .7687 | .772 | / | | | |
| 2.90 | ±0.030 | 2.90 | / | | | |
| 7.750 | ±0.015 | 7.747 | / | | | |
| .375 | +0.000 -0.010 | .370 | / | | | |
| R.25 | ±0.030 | R.25 | / | | | |
| R.50 | ±0.030 | R.50 | / | | | |
| | | | | | | |
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|-----------------|-------------------------|---------------------|-----|
| Measured by: SA | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 09/01/27 | Date: 09/01/28 | Date: | N/A |

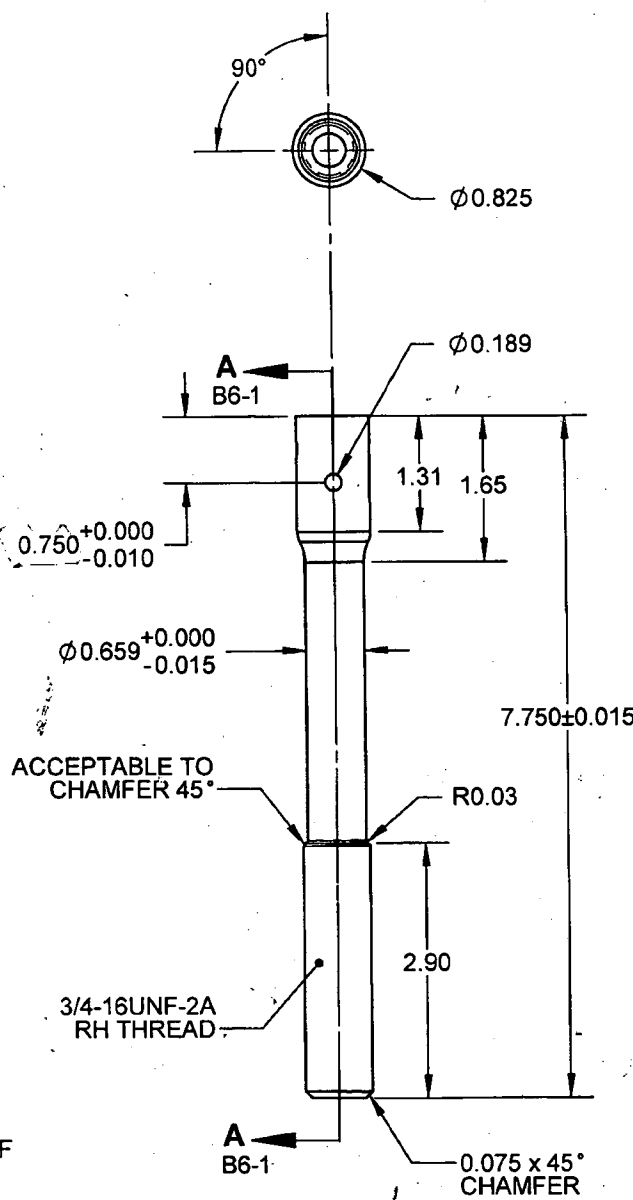
| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |



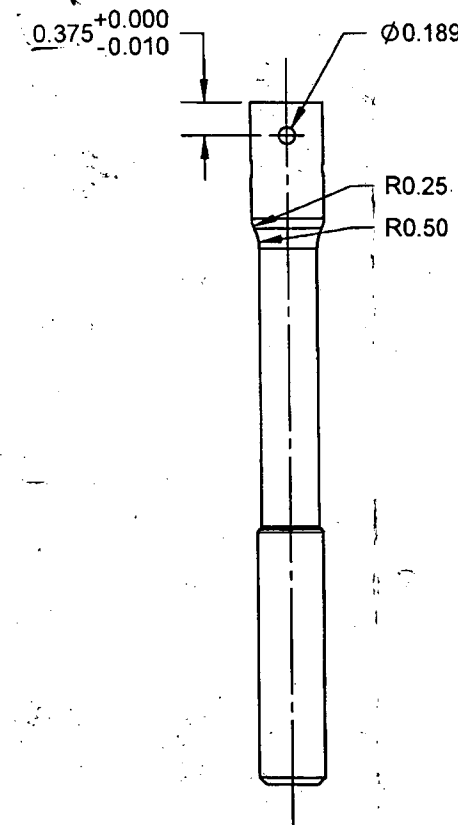
DETAIL B
SCALE 2X
C6-1



SECTION A-A
D4-1



D3691-1 STUD



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 14820

RELEASED
08/12/15

- NOTES:**
- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.81 lb
 - 8) LPI PER ASTM 1417 LEVEL 2

| | | | |
|------------|--|--|--------------|
| B | CHANGE TO 17-4PH H-900(ZN A8-1); Ø0.695 WAS Ø0.665 (ZN D8-1); REFORMATTED TO CURRENT DWG STANDARDS | RF | 08.11.24 |
| A | NEW ISSUE | RF | 08.03.12 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | RF | DRAWING NO. | REV. B |
| MFG. APPR. | RF | D3691 | SHEET 1 OF 1 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | STUD | NTS |
| DATE | 08.11.24 | COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

